

5/14

DUPLICATE

<b>DART AEROSPACE LTD.</b>	<b>Work Order:</b>	<b>22713</b>
<b>Description:</b> Saddle Fitting, Fwd (Outboard/Inboard)	<b>Part Number:</b>	<b>D2571/D2572</b>
<b>Drawing:</b> D2571 Rev. D/D2572 Rev. D	<b>Qty:</b>	<b>12</b>
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Dwg not required</b>	KG	05.06.06	12
2	MV	Make from D6101-007 billet for D2571 <b>Ensure that grain is along 7.75" length</b> Batch No: B21862	BC	05/06/07	12
3	MV	Make from D6101-005 billet for D2572 <b>Ensure that grain is along 5.00" length</b> Batch No: B23249	BC	05/06/07	12
4	MV	Fixturing W/O No. <u>N/A</u> Fixturing Inspection last completed 05/06/07 by BC	BC	05/06/07	12
5	MV	Program Batch No. <u>22713</u> Double check by: <u>CD</u>	BC	05/06/07	12
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	BC	05/06/11	12
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	BC	05/06/11	12
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	BC	05/06/11	12
9	MV	Machine keyway as per dwg D2571 & D2572	BC	05/06/11	12
10	MV	Deburr and remove all machining marks	BC	05/06/11	12
11	MV	Tumble for 20 minutes to remove sharp edges # 04.06.21	BC	05/06/11	12
12	QC1	Inspect all dimensions to dimension sheets	BC	05/06/11	12
13	QC7	Second inspection	CD	05/06/12	12
14	FP	Acid etch and alodine as per QSI 005 4.1	MM	05/06/13	12
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	MM	05/06/13	12
16	QC3	Inspect Powder Coat	CL	05/06/13	12
17	ST	Identify and Stock.	CL	05/06/13	12
18	AC	Cost / Part <u>139.41</u> <u>139.41</u> <u>153.81</u> <u>142.24</u>	AP	05/06/14	12
19	DC	Close W/O Inspection Level 21	KG	05.06.16	12

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	

RELEASED  
02/10/15 RF